

Work Order ID 54718 -2

December 17, 2009 8:21:18 AM

TODAY

Page 1

Item ID: D3480-3

Spick *8/09/12/17*

Accept



Setup Start



Revision ID:

Item Name: Tube

Stop



Start Date: 12/17/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 12/17/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *09-12-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3480

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3480

B/B

B 9-12-17

304 108

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-12-17

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8/09/12/17

(XS)

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Page 2

Item ID: D3480-3

Accept



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Stop



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Cust Item ID:

Required Date: 12/17/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

1-Roll as per dwg D3480 2-Spot weld as per dwg D3480 3-Deburr 8/09/12/17

8/09/12/17

7 M, 10/03/09

44

140



QC

Quality Control

QC11- Inspect spot weld per QSI004

0.00

Memo

0.00

8/10/03/09

44

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/03/10

44

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Page 3

Item ID: D3480-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 12/17/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 12/17/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: 64

0.00

Memo

0.00

Packaging

PL 10/3/10 (4)

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*10/03/11**PL 10-3-10*

Picklist Print

December 17, 2009 8:21:18 AM

Page 1
1

Work Order ID: 54718



Parent Item: D3480-3



Parent Item Name: Tube

Start Date: 12/17/2009

Required Date: 12/17/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304S26GA | | Purchased | No | | | | sf | 171.0064 | 0.2401 | | | |



304/316 0.018 SHEET



B9-12-17

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

171.0063895

105591

0.39

107021

1.21

108415

3.19

109398

70.2163895

112885

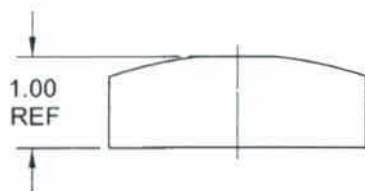
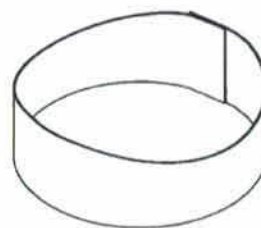
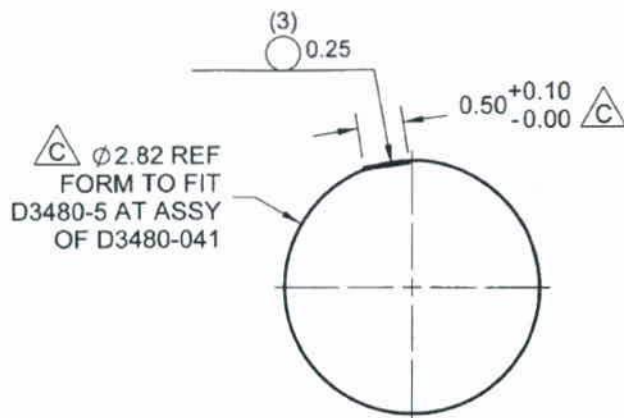
96

109398

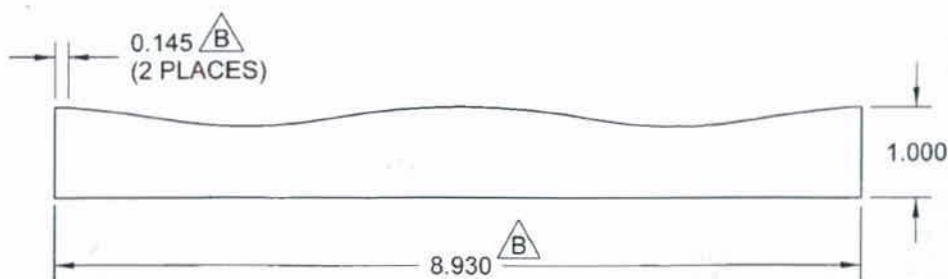


| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3480 | REV. C SHEET 4 OF 6 |
| DATE 08.12.19 | | TITLE EYEBALL ADAPTER | SCALE 1:2 |

RELEASE
09/01/30 WPD



D3480-3 TUBE



D3480-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 76

EMPLOYEE: Marc Gregory

PART NUMBER: D 3480-3

JOB NUMBER: 54718

MATERIAL TYPE: 301

MATERIAL THICKNESS: 0.18

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium SS

TEST RESULTS

VISUAL: [☒]

FAIL []

PENETRATION: [☒]

[]

PULL STRENGTH: [☒]

[] PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 10/03/09

QUALIFIER: SB